

Date: Friday, 17/08/2007 11:20:47 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD PLATE ASSEMBLY  
 Job Number : 34079  
 Estimate Number : 12222  
 P.O. Number : *N/A* Part Number : D3467043  
 This Issue : 17/08/2007 S.O. No. : *N/A* Drawing Number : D3467 REV B  
 Prsht Rev. : NC Project Number : *N/A*  
 First Issue : *N/A* Type : SMALL / MED FAB Drawing Revision : B  
 Previous Run : 26947 Material : *N/A*  
 Due Date : 11/09/2007 Qty: *10* Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev: A New Issue 06-04-24 JLM  
 Est Rev: B As per Rev B 06-05-24 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34679 FWD PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~1.0000~~ Each(s)

Pick:

| Qty | Part Number | Description | Batch              |
|-----|-------------|-------------|--------------------|
| 1   | D3467-9     | Fwd Plate   | <i>B34102</i> X 10 |

2.0 NAS1031C3W Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : ~~24.0000~~ Each(s) *60*

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---|
| 6   | NAS1031C3W  | Nut Plate   | <i>M101462</i> X 26 ✓ / <i>M105559</i> X 34 * |

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

X 10

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 02/05/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:20:47 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD PLATE ASSEMBLY

Job Number: 34079

Part Number: D3467043

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/09/11

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/09/11

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5159

SB 07/09/11

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/09/11

Job Completion



W 07/09/11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

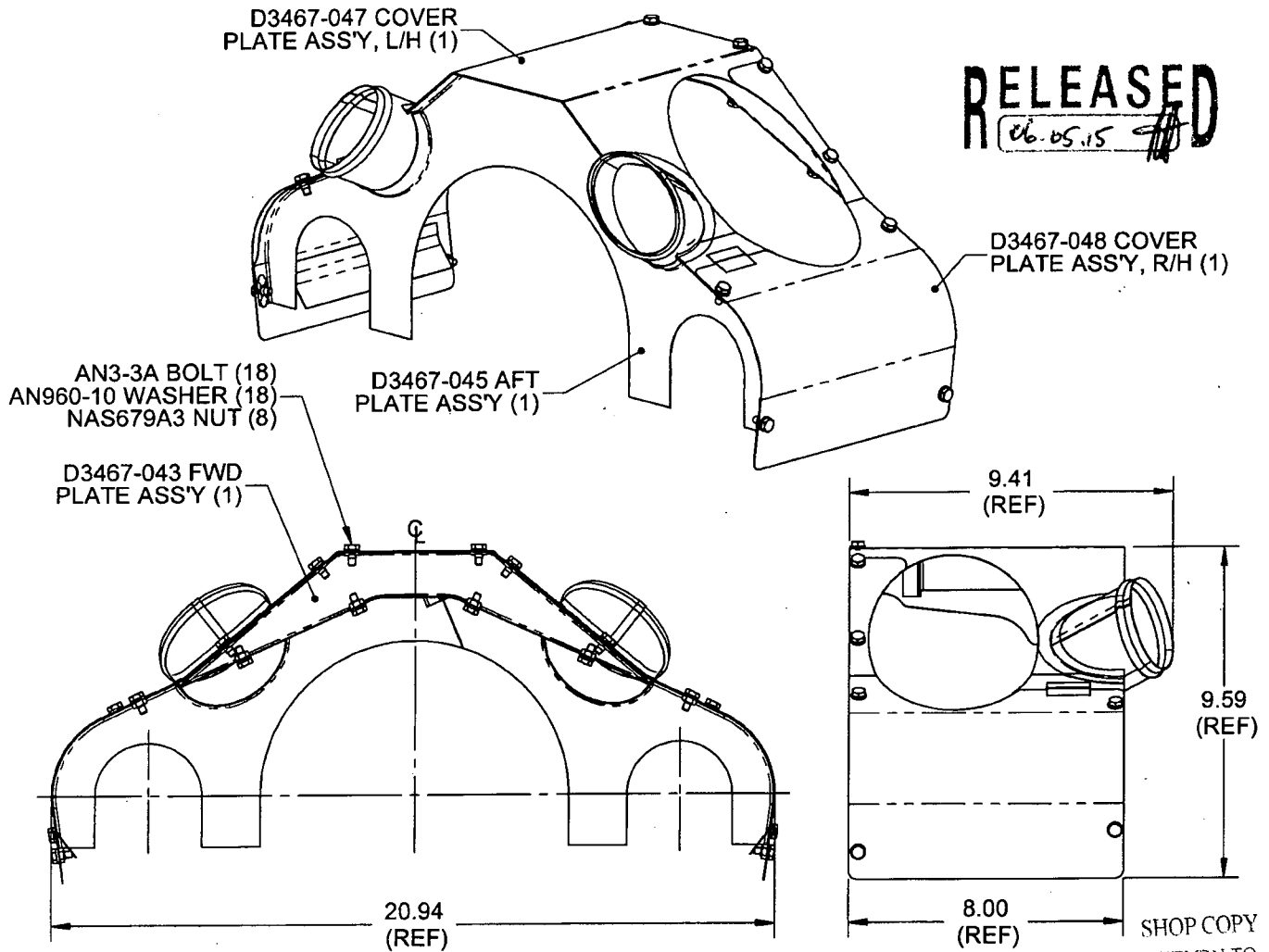
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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| CHECKED<br>H     | APPROVED<br>H  | DRAWING NO.<br>D3467                                   | REV. B<br>SHEET 1 OF 15 |
| DATE<br>06.05.15 |                | TITLE<br>SHROUD ASSEMBLY                               | SCALE<br>1:5            |
| A                | 05.12.07       | NEW ISSUE  |                         |
| B                | 06.05.15       | Ø0.250 & Ø0.203 WERE Ø0.194 ;<br>UPDATED D3467-9F/-15F |                         |

**D3467-041 SHROUD ASSEMBLY****NOTES:**

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

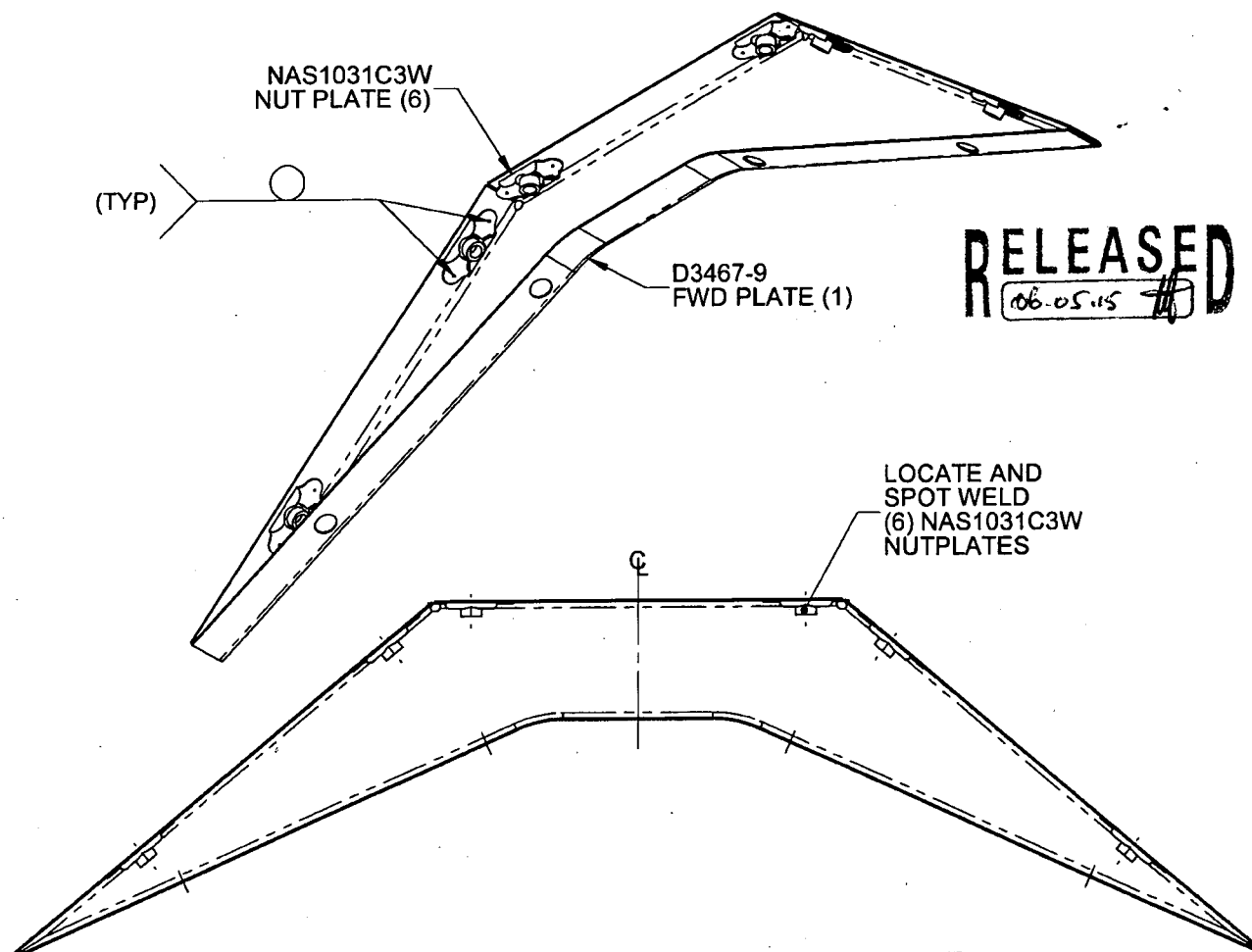
| QTY<br>-041 | P/N       | DESCRIPTION               |
|-------------|-----------|---------------------------|
| X           | D3467-041 | SHROUD ASSEMBLY           |
| 1           | D3467-043 | FWD PLATE ASSEMBLY        |
| 1           | D3467-045 | AFT PLATE ASSEMBLY        |
| 1           | D3467-047 | COVER PLATE ASSEMBLY, L/H |
| 1           | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 18          | AN3-3A    | BOLT                      |
| 18          | AN960-10  | WASHER                    |
| 8           | NAS679A3  | NUT                       |

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| DATE<br>06.05.15              |                                | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:2            |



| QTY<br>-043 | P/N        | DESCRIPTION        |
|-------------|------------|--------------------|
| X           | D3467-043  | FWD PLATE ASSEMBLY |
| 1           | D3467-9    | FWD PLATE          |
| 6           | NAS1031C3W | NUT PLATE          |

### D3467-043 FWD PLATE ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

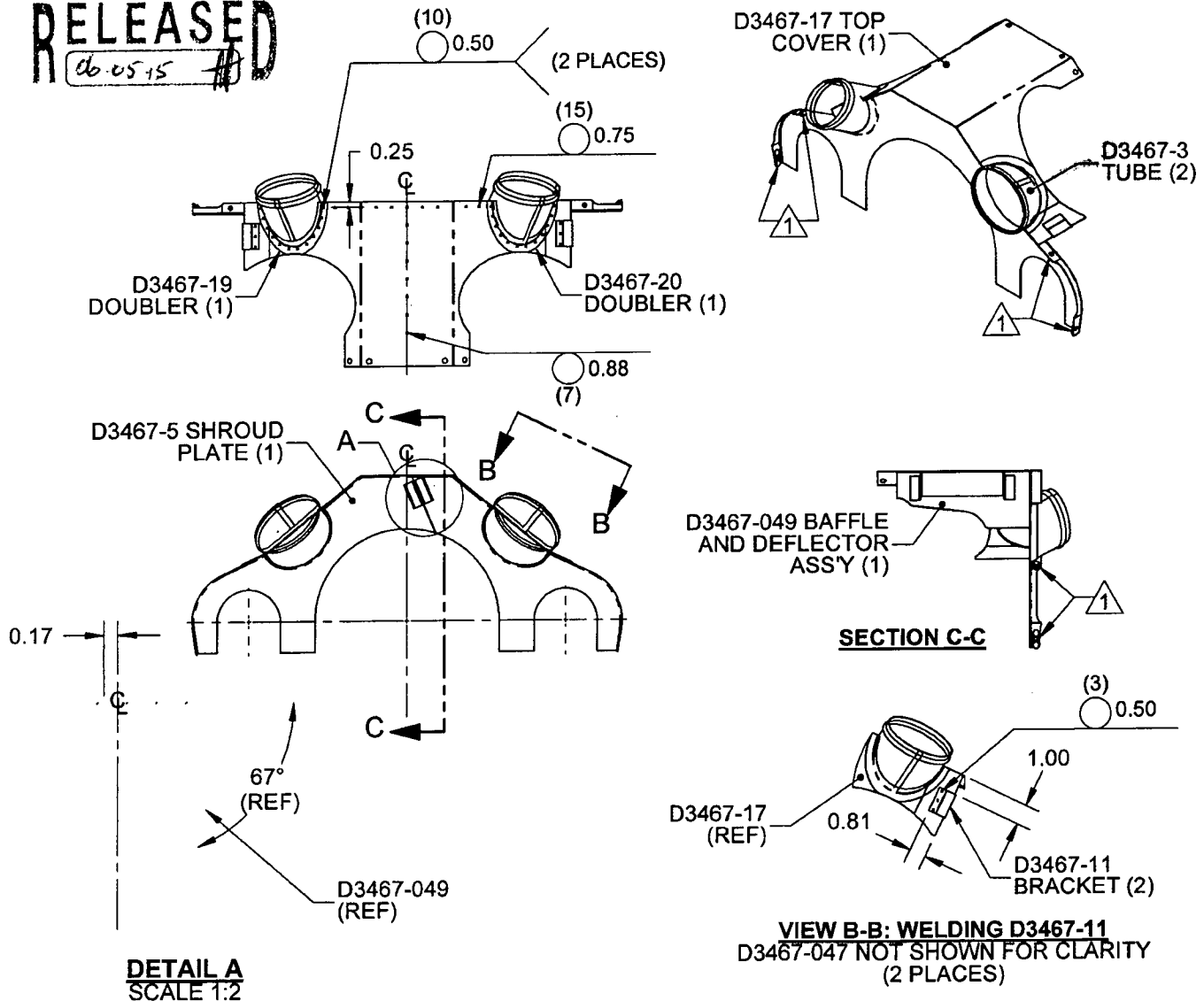
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| DATE<br><b>06.05.15</b> |               | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:8            |

**RELEASED**  
06.05.15**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

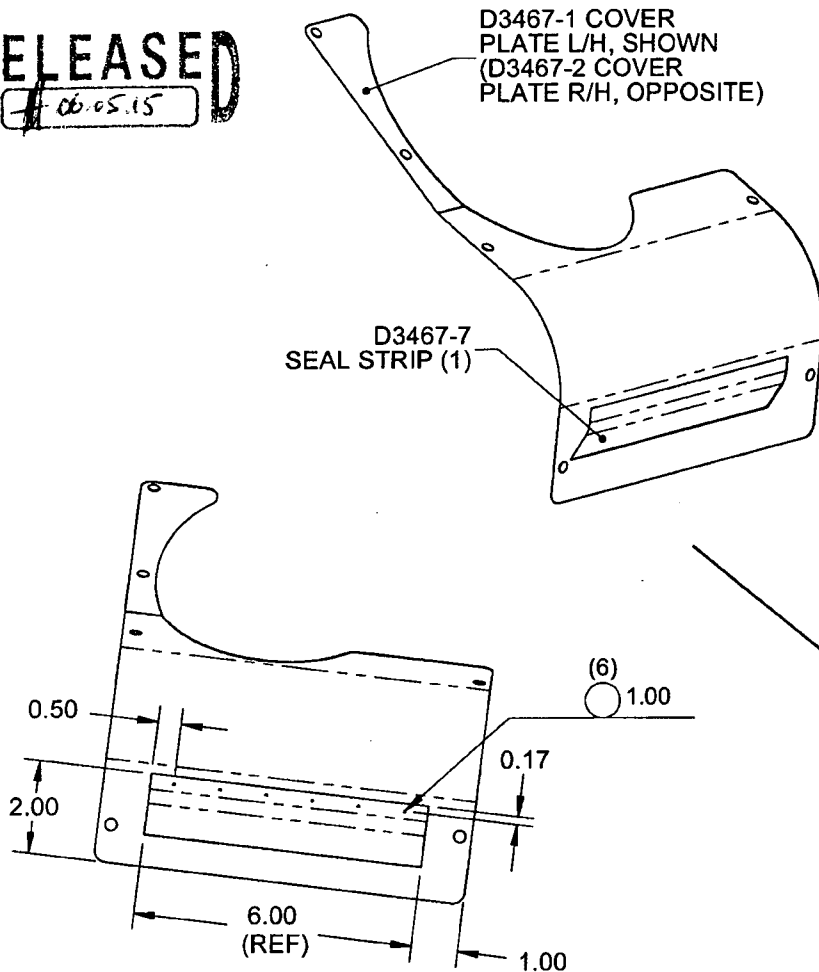
| QTY<br>-045 | P/N        | DESCRIPTION                   |
|-------------|------------|-------------------------------|
| X           | D3467-045  | AFT PLATE ASSEMBLY            |
| 1           | D3467-049  | BAFFLE AND DEFLECTOR ASSEMBLY |
| 2           | D3467-3    | TUBE                          |
| 1           | D3467-5    | SHROUD PLATE                  |
| 2           | D3467-11   | BRACKET                       |
| 1           | D3467-17   | TOP COVER                     |
| 1           | D3467-19   | DOUBLER                       |
| 1           | D3467-20   | DOUBLER                       |
| 4           | NAS1031C3W | NUT PLATE                     |

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| DATE<br>06.05.15    |                      | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:4            |

**RELEASED**  
06.05.15

**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

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**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-047 | QTY<br>-048 | P/N       | DESCRIPTION               |
|-------------|-------------|-----------|---------------------------|
| X           |             | D3467-047 | COVER PLATE ASSEMBLY, L/H |
|             | X           | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 1           |             | D3467-1   | COVER PLATE, L/H          |
|             | 1           | D3467-2   | COVER PLATE, R/H          |
| 1           | 1           | D3467-7   | SEAL STRIP                |

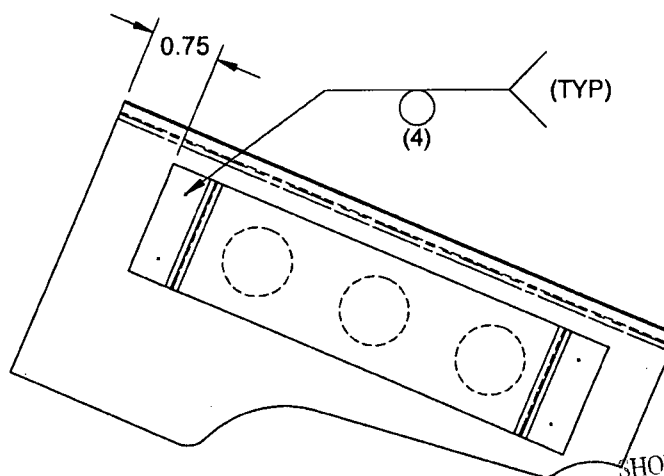
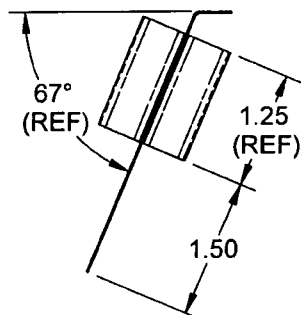
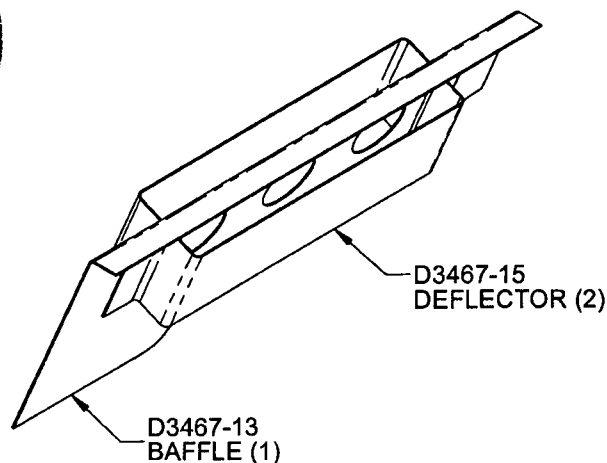
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| DATE<br>06.05.15    |                       | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:2            |

**RELEASED**  
*06.05.15***D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

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**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

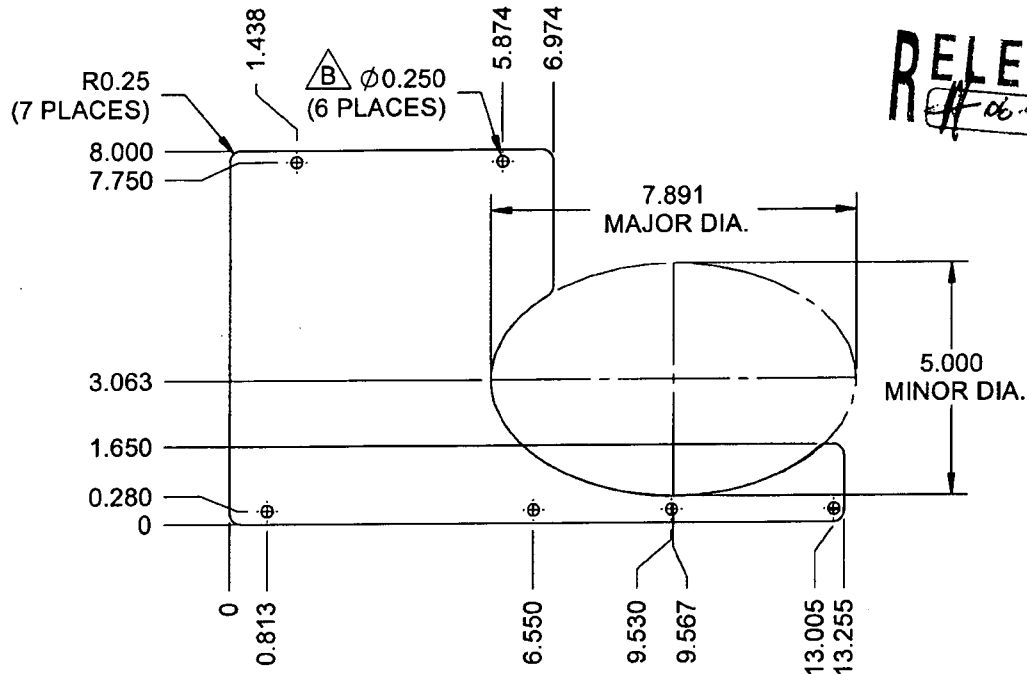
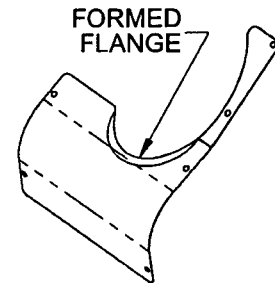
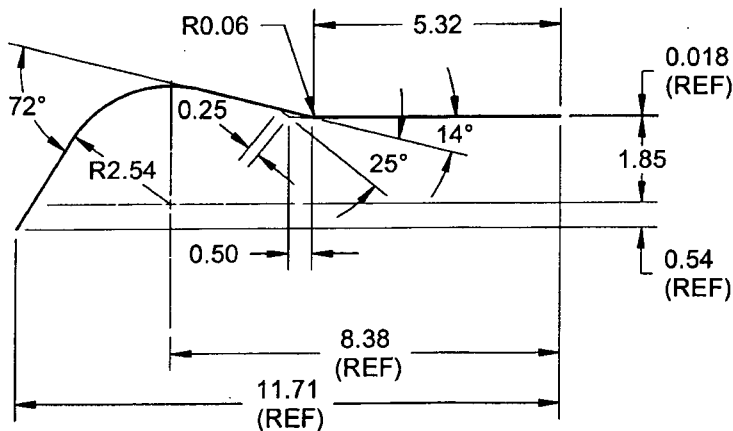
| QTY<br>-049 | P/N       | DESCRIPTION                 |
|-------------|-----------|-----------------------------|
|             | D3467-049 | BAFFLE & DEFLECTOR ASSEMBLY |
| 1           | D3467-13  | BAFFLE                      |
| 2           | D3467-15  | DEFLECTOR                   |

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| DATE<br>06.05.15 |                | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:4            |

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER  
PLATE ISOMETRIC VIEW.**  
**D3467-2 R/H COVER  
PLATE (OPPOSITE)**  
SCALE 1:8**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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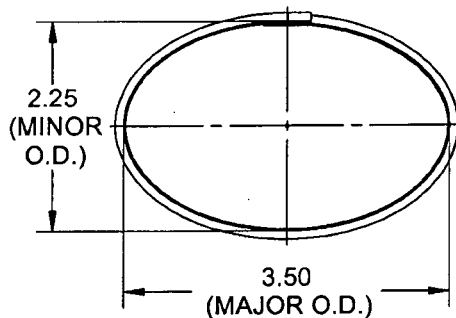
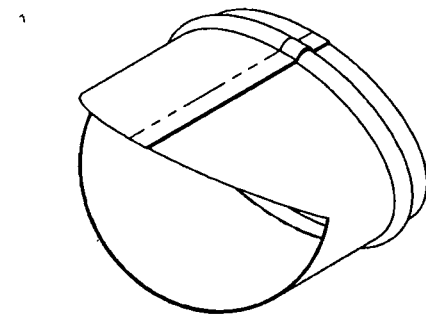
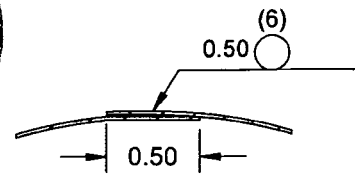
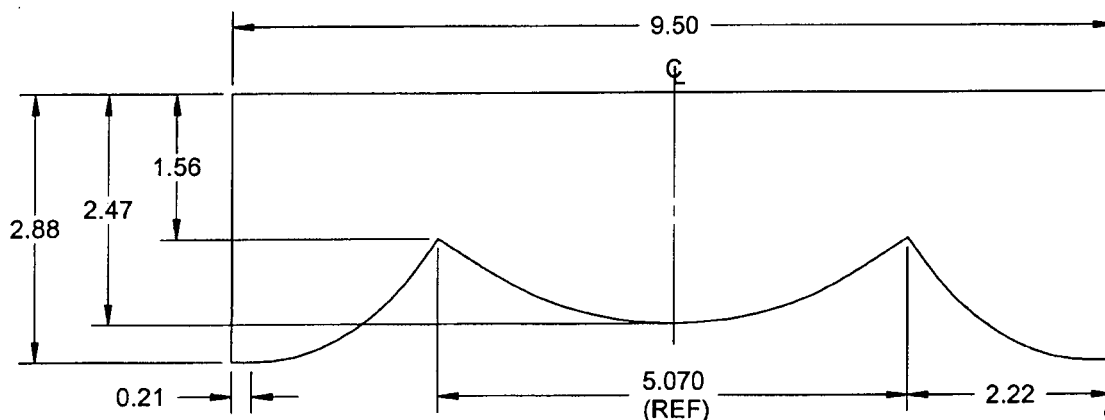
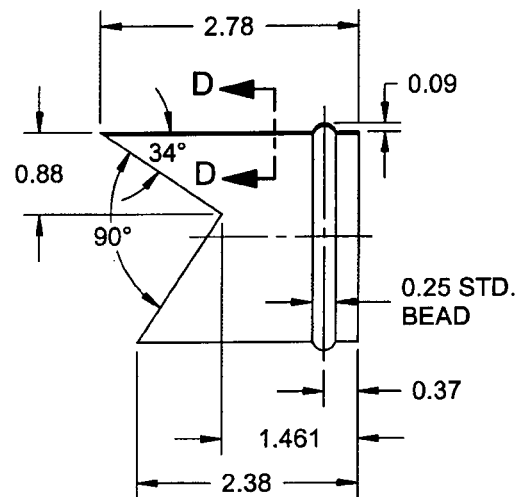
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| DATE<br><b>06.05.15</b> |                         | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2            |

**RELEASED**  
06.05.15**D3467-3 TUBE DETAIL****SECTION D-D**  
SCALE 1:1**D3467-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

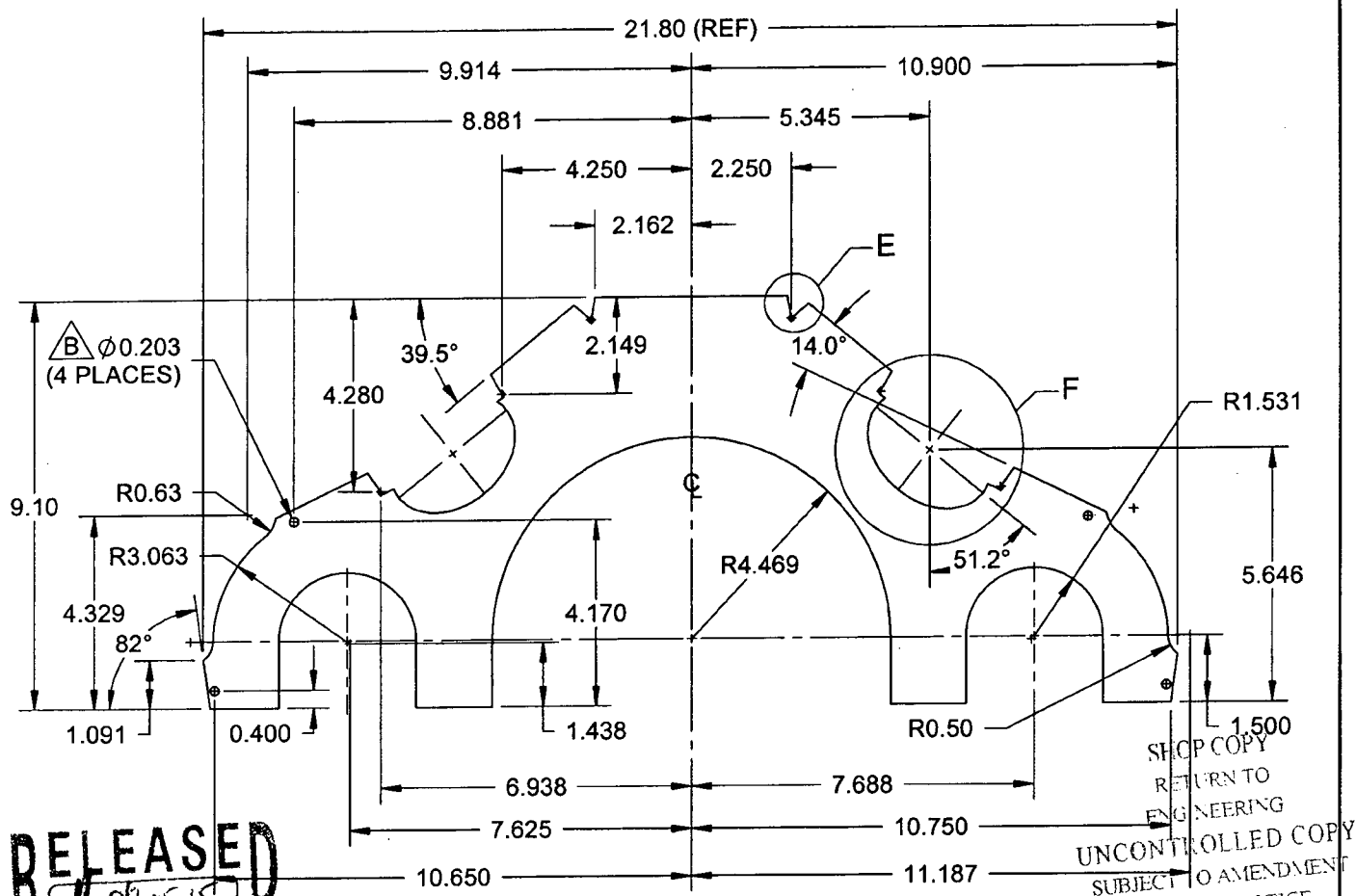
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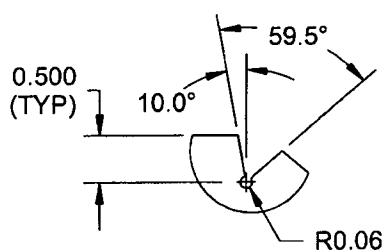
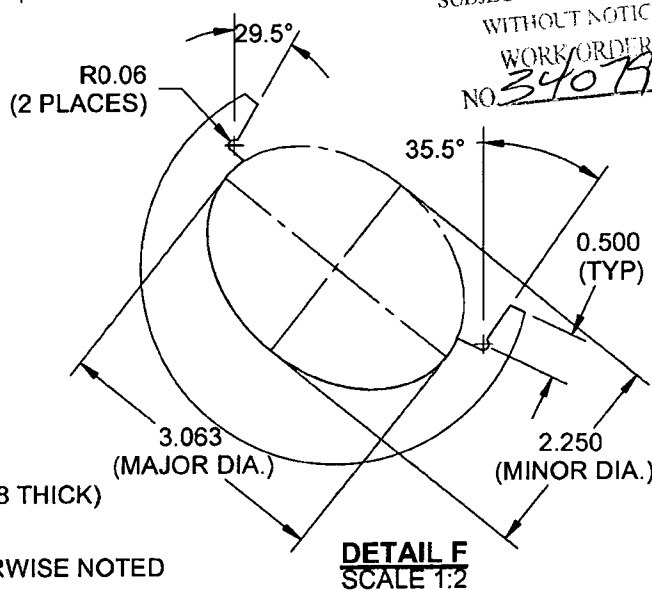
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| DATE<br><b>06.05.15</b> |                      | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:8            |

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# 06-05-15

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NO. *3407B*

**DETAIL E**  
SCALE 1:2**DETAIL F**  
SCALE 1:2**D3467-5F AFT PLATE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019  
(ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

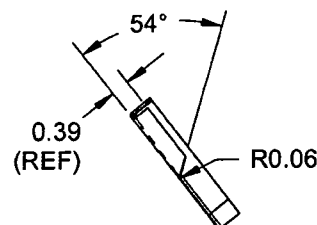
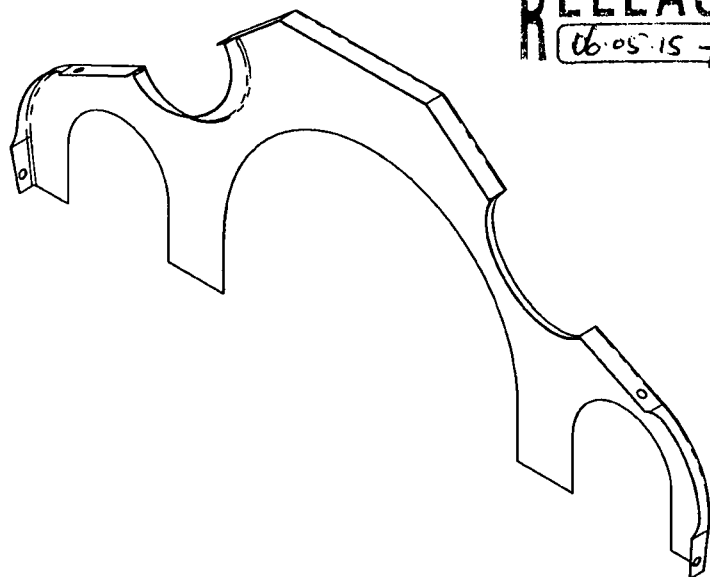
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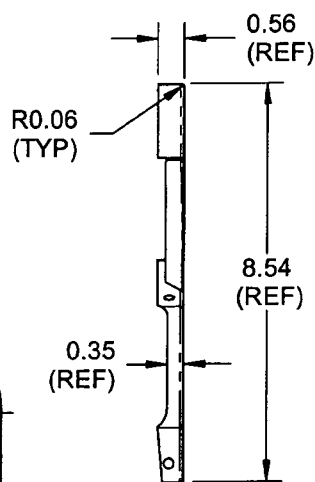
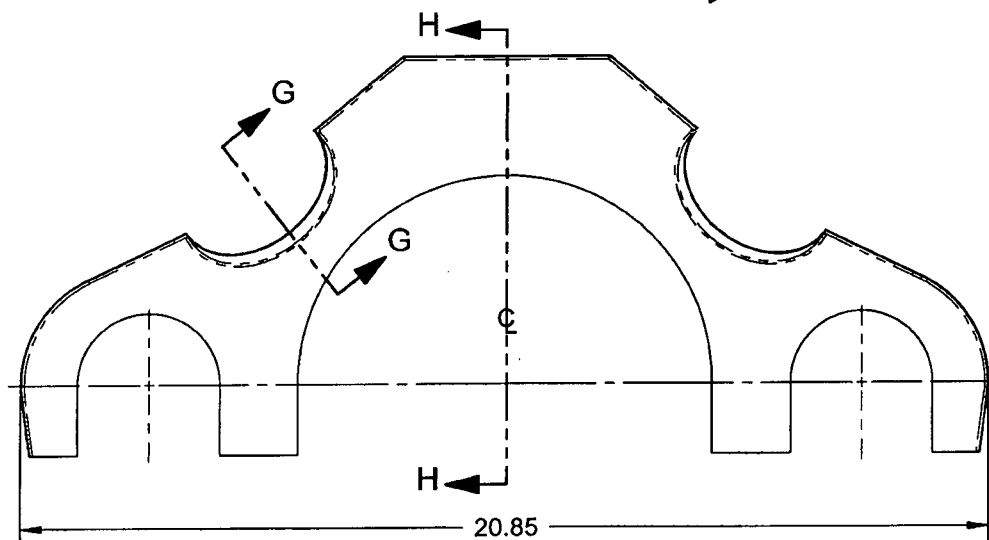


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|----------------------|-----------------------|---|-------------------------|
| DESIGN<br><i>JB</i>  | DRAWN BY<br><i>JB</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br><i>JB</i> | APPROVED<br><i>JB</i> | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 9 OF 15 |
| DATE<br>06.05.15     |                       | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:4            |

RELEASED  
06.05.15



**SECTION G-G**



**SECTION H-H**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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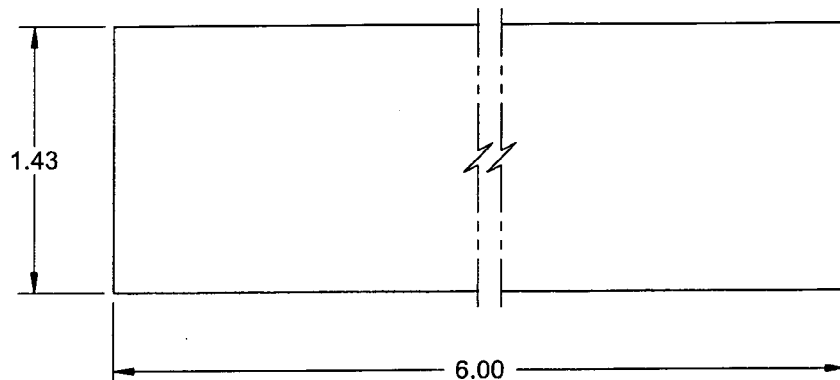
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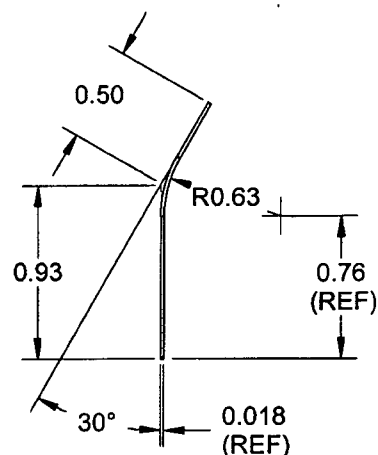


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| DESIGN<br><i>B</i>  | DRAWN BY<br><i>B</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                          |
| CHECKED<br><i>#</i> | APPROVED<br><i>#</i> | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 10 OF 15 |
| DATE<br>06.05.15    |                      | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:1             |

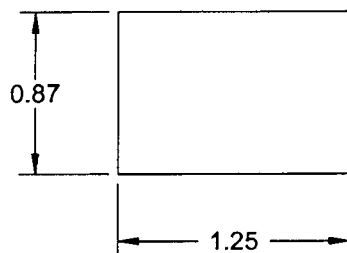
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06.05.15 *#*



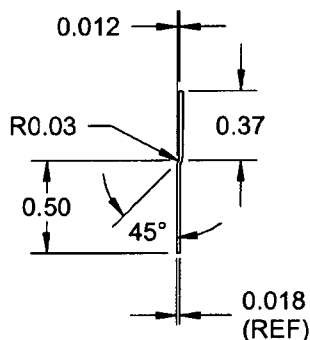
**D3467-7F SEAL STRIP  
FLAT PATTERN**



**D3467-7 SEAL STRIP  
BENDING DETAIL**



**D3467-11F BRACKET  
FLAT PATTERN**



**D3467-11 BRACKET  
JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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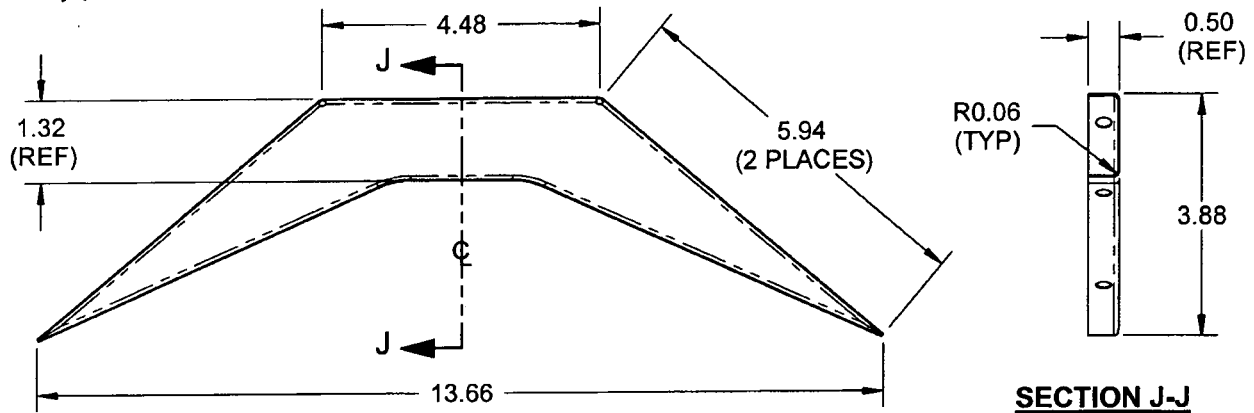
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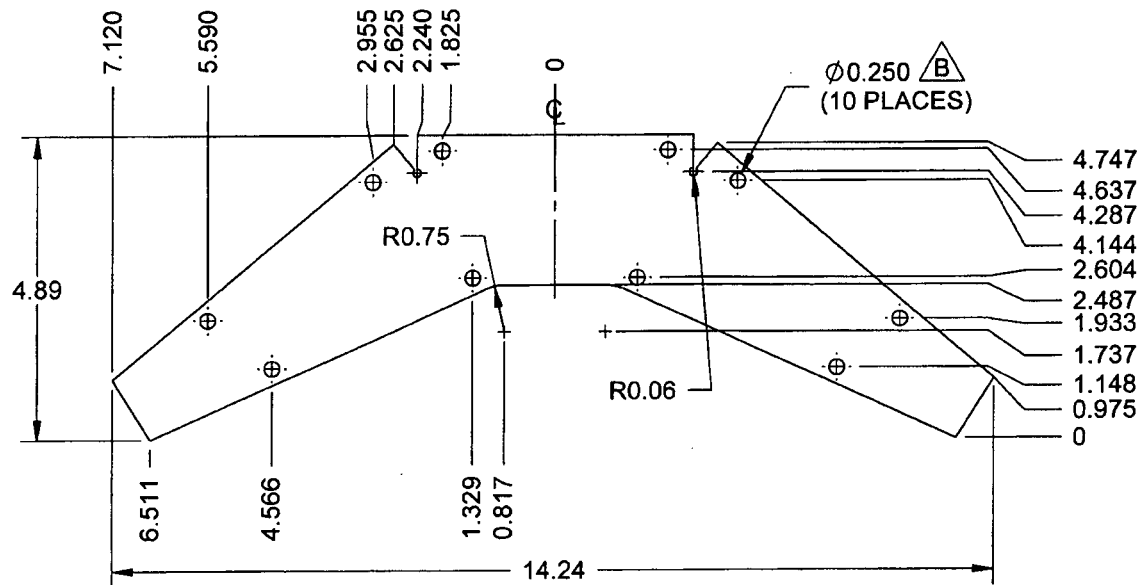


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| CHECKED<br><i>H</i> | APPROVED<br><i>H</i> | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 11 OF 15 |
| DATE<br>06.05.15    |                      | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:3             |

RELEASED  
06.05.15



**D3467-9 FWD PLATE BENDING DETAIL**



**D3467-9F FWD PLATE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

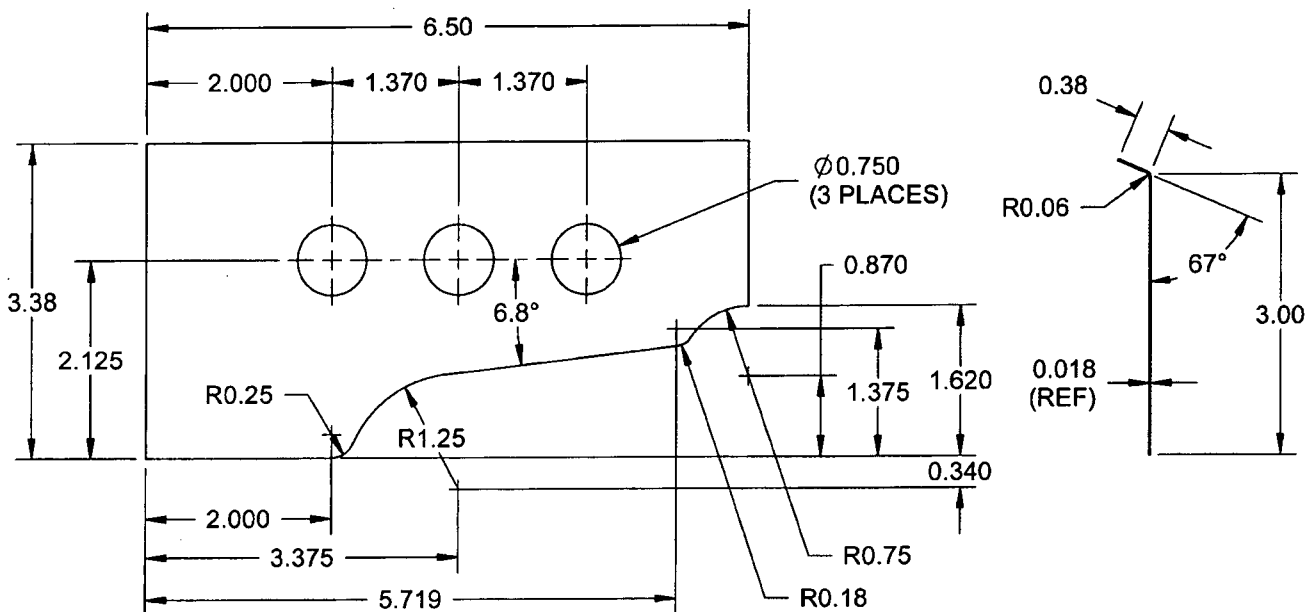
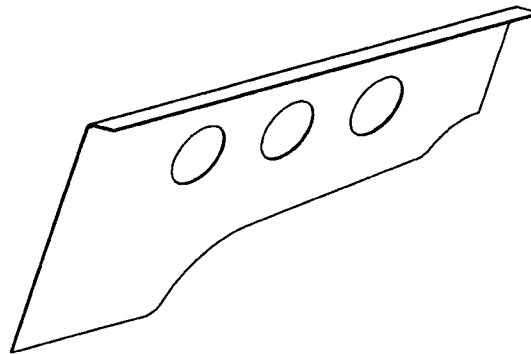
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| DATE<br>06.05.15    |                      | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:2             |

**RELEASED**  
*06.05.15***D3467-13F BAFFLE  
FLAT PATTERN****D3467-13 BAFFLE  
BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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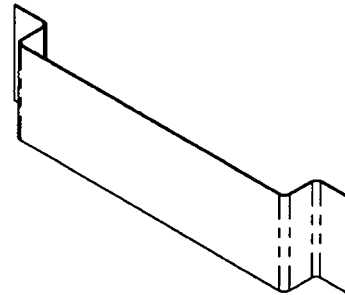
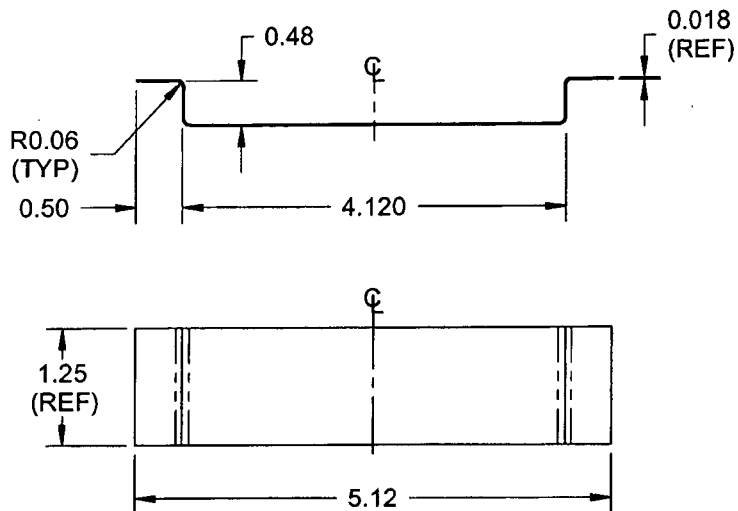
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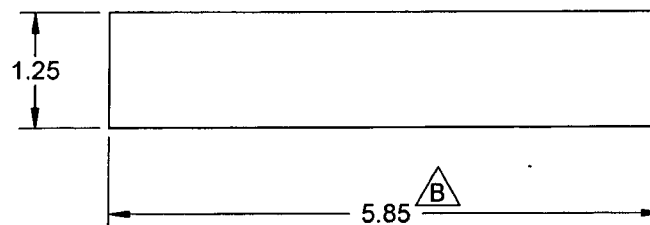


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| DATE<br>06.05.15     |                       | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:2             |

RELEASED  
*06.05.15*



### D3467-15 DEFLECTOR BENDING DETAIL



### D3467-15F DEFLECTOR FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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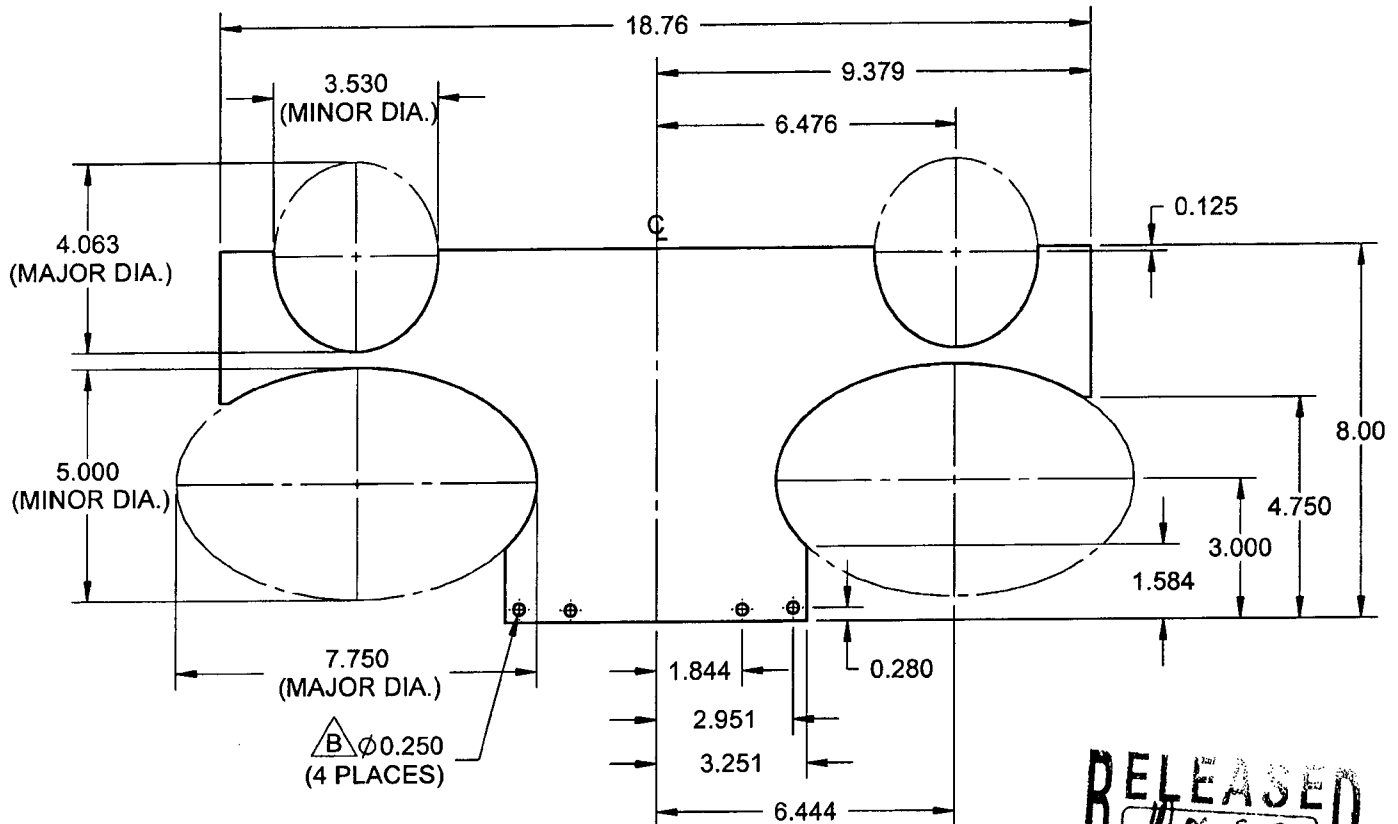
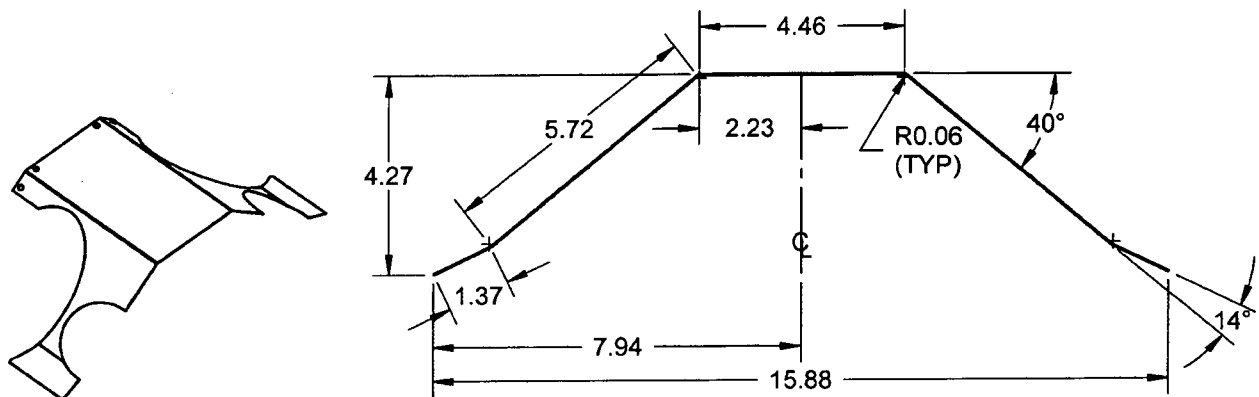
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 14 OF 15 |
| DATE<br><b>06.05.15</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:4             |

**D3467-17F TOP COVER FLAT PATTERN****RELEASED**  
*[Stamp]***D3467-17 TOP COVER BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

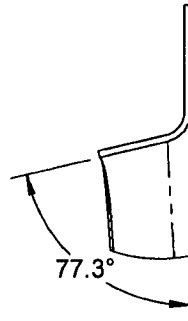
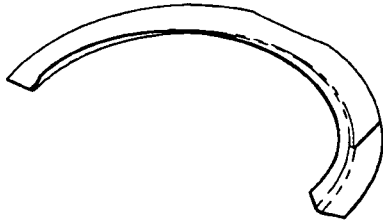
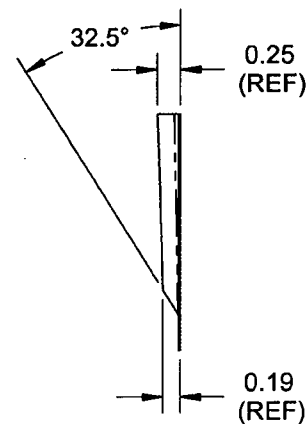
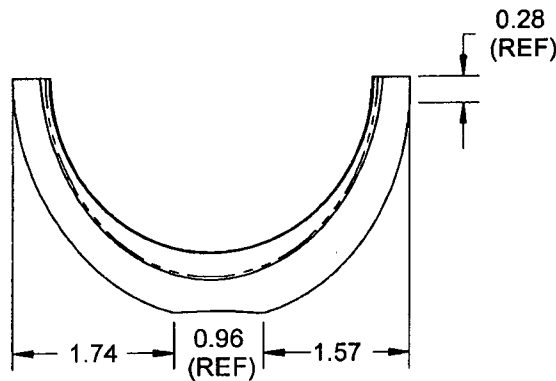
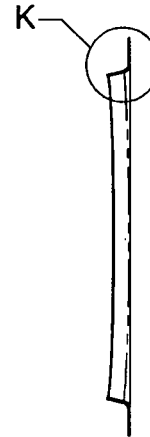
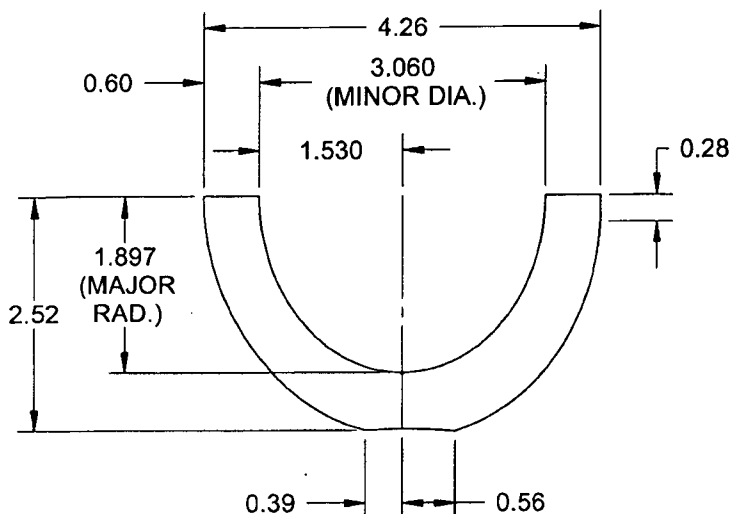
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| DATE<br><b>06.05.15</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2             |

**RELEASED**  
*[Signature]* 06.05.15**DETAIL K**  
SCALE 1:2**D3467-19 DOUBLER, L/H SHOWN**  
**D3467-20 DOUBLER, R/H OPPOSITE**SHOP COPY  
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*34079***D3467-19F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 11

EMPLOYEE: Melanie Fautney

PART NUMBER: D 3477 - 041

JOB NUMBER: B 31258

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: 018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium

## TEST RESULTS

|                | PASS                                | FAIL                     |
|----------------|-------------------------------------|--------------------------|
| VISUAL:        | <input checked="" type="checkbox"/> | <input type="checkbox"/> |
| PENETRATION:   | <input checked="" type="checkbox"/> | <input type="checkbox"/> |
| PULL STRENGTH: | <input checked="" type="checkbox"/> | <input type="checkbox"/> |

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/09/11

QUALIFIER: SB